

# Work Order ID 75445

**\*75445\***

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October-21-11 2:45:16 PM

Item ID: D3578-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Doubler  
 Start Date: 21/10/2011 Start Qty: 40.00 **\*40\*** Cust Item ID:  
 Required Date: 10/11/2011 Req'd Qty: 40.00 **\*40\*** Customer:  
 Reference:

Approvals: Process Plan: M.L. J Date: 11/10/24 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3578	Rev A								

100 FLOW WATER JET 0.00  
**\*100\*** Waterjet Memo 0.00 B11-10-26

FLOW CNC Waterjet  
 6061, 080  
 1-Cut as per Dwg D3578 (Run prog. D3578-1)  
 Dwg Rev: A  
 Prog Rev: A  
 2-Deburr if necessary B11-10-28

110 QC2- Inspect parts off machine FAI/FAIB 0.00  
**\*110\*** QC Memo 0.00 B11-10-26  
 Quality Control

120 QC8- Inspect parts - second check 0.00  
**\*120\*** QC Memo 0.00 Sukol28 counted (x49)  
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-Open rivet holes to 0.098" and C'sink as per dwg D3578								
140 <b>*140*</b> QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150 <b>*150*</b> HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00							

*[Handwritten signature]* 11/10/31 (49)

*[Handwritten signature]* 11 10 31 (49)

49 BR 11-11-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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 Required Date: 10/11/2011 Req'd Qty: 40.00 **\*40\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 <b>*160*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							49 x 10 m - 10/11/01
170 <b>*170*</b> Small Fab Small Fab	Small Fab  Memo 1-Assemble as per dwg D3578	0.00  0.00							11/11/03 (49)
180 <b>*180*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							11-11-03 (49)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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 Required Date: 10/11/2011 Req'd Qty: 40.00 **\*40\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <b>ST 245A</b>	0.00							
<b>*190*</b>									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
<b>*200*</b>									
QC	Memo	0.00							
Quality Control									

**Sp 11-11-03**

**11/11/3**

**11-11-03**  
**(49)**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 75445

**\*75445\***

Parent Item: D3578-041

**\*D3578-041\***

Parent Item Name: Doubler

Start Date: 21/10/2011

Required Date: 10/11/2011

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP: A07.04.11New issueEC

IPP RevB 10.10.21 remove D3569-1 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20426AD3-3		Purchased	No			110	Each	4,243.000	2	80			
<b>*MS20426AD3-3*</b>									**				
Rivet													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST316				1243					
					19099			1243					
				ST317				3000					
					119109			3000					
M6061T6S.080		Purchased	No			170	sf	270.8000	0.007	0.294737			
<b>*M6061T6S 080*</b>									**				
6061-T6 .080 Sheet													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT021				270.8					
					117285			18.8					
					119009			171					
					119028			81					
MS21075L3		Purchased	No			170	Each	90.0000	1	40			
<b>*MS21075L 3*</b>									**				
Nutplate													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST303				90					
					117677			90					

*ES 11/11/03*

*98*

*11-10-2C*

*49*

*ES 11/11/03*

*49*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

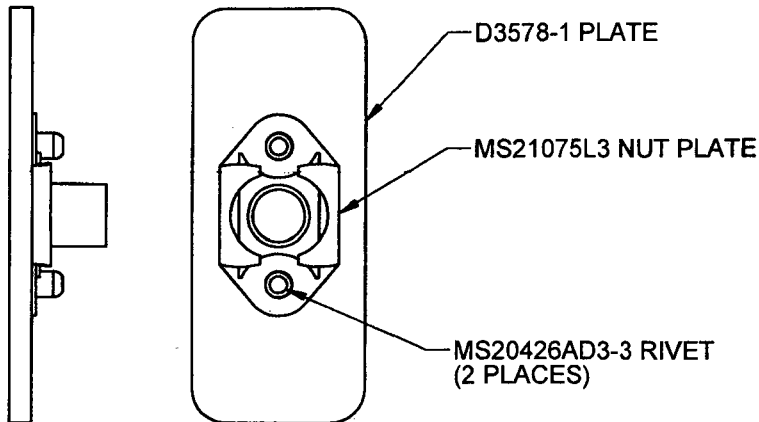
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**DART**

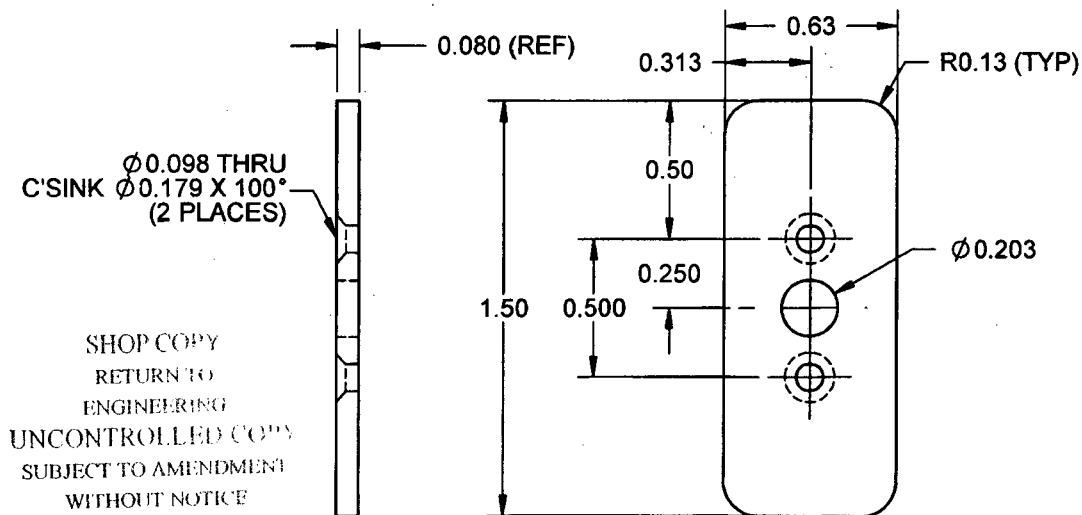
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JB</i>	APPROVED <i>JB</i>	DRAWING NO. <b>D3578</b>	REV. A SHEET 1 OF 1
DATE <b>07.01.12</b>	TITLE <b>DOUBLER</b>		SCALE 3:2
REV A	DATE 07.01.12	DESCRIPTION NEW ISSUE	

**RELEASED**  
07.04.02**D3578-041 PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D3578-041	DOUBLER
1	D3578-1	PLATE
1	MS21075L3	NUT PLATE
2	MS20426AD3-3	RIVET

**D3578-041 DOUBLER****D3578-041 NOTES:**

1) IDENTIFY WITH DART P/N "D3578-041" USING FINE POINT PERMANENT INK MARKER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENTWITHOUT NOTICE  
WORK ORDERNO. 75445  
*M.L.J.*  
*11/10/24***D3578-1 PLATE****D3578-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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